# \*111514\*

Page 1

Name	January-15-14	1:17:06 PM	·	· · · · · · · · · · · · · · · · · · ·								
Item Name: Washer		D3456-1		Accept	*N900	040	100	<b>)*</b> s	etup Star	t *N	S1*	
Start Date:   1/15/14   Start Qty: 40.00		Washer	100						Stop	. +NI	C O*	
Required Date: 1/30/14 Req'd Qty: 40.00  Reference:  Approvals: Process Plan: Operation Octoor Set Up/ Date: SPC (Y/N): Sequence ID/ Operation Description Set Up/ Run Hours Code Qty Qty Stamp    Draw Nbr			00 *10*	$\overline{}$	C	Th.				171	<b>5</b> /"	
Reference:   Process Plan:   Date:   U - Cl - (Lo   Tooling:   Date:   SPC (Y/N):   Date:   Stop   * NR2*   N		~ "				D:						
Approvals: Process Plan: Approvals: Date: 14-Ol-14 Tooling: Date: SPC (Y/N): Date: Stop *NR1*  Sequence ID/ Operation Set Up/ Run Hours Tool ID Tool # Plan Code Oty Oty Number Stamp  Draw Nbr Revision Nbr D3456 Rev A  100  *100	_	1/30/14 <b>Req u Qiy:</b> 40.	.00 <b>*410*</b>		Customer:							
Sequence ID/ Work Center ID Description Set Up/ Work Center ID Description Set Up/ Run Hours Tool ID Tool # Plan		Process Plan: 1 A/4	▼ Date:   U -()  -((o	Teoling:	De	ate:	<del>-</del>	R	lun Star	<sup>t</sup> *N	R1*	
Sequence ID/ Work Center ID Description Set Up/ Run Hours Tool ID Tool # Plan Code Qty Qty Number Reject Reject Reject Reject Reject Run Hours Stamp  Draw Nbr Revision Nbr  D3456 Rev A  100  **100** PURCHASING PURCHASING Purchasing Memo Supplier: McMaster-CarrMaterial release note is required  110 Receive & Inspect for Damage & Mat'l Certs Supplier: McMaster-CarrMaterial release note is required  110 Receive & Inspect for Damage & Mat'l Certs D00  **110** Packaging Memo D00  COde D1/ D1/ D2/ D350 P/N: 91525A120 per Dwg D3456Possible  110 Receive & Inspect for Damage & Mat'l Certs D00  **110** Packaging Memo D00  COde D34 D45 D45 D45 D45 D45 D45 D45 D45 D45 D4	PF	<del></del>	•						Stop	, TVI		
Description   Run Hours   Code   Qty   Qty   Number   Stamp		QC.	Date.	_ 51 € (1/14).		atc				^IVI	<b>Hン</b> ^	
D3456 Rev A  100  *100  *100*  PURCHASING  Purchasing  Memo  0.00  Susue P/O: 20652 P/N: 91525A120 per Dwg D3456Possible Supplier: McMaster-CarrMaterial release note is required  110  Receive & Inspect for Damage & Mat'l Certs Packaging  Memo  0.00  *110* Packaging  Memo  0.00  Packaging  Memo  0.00  DAS  27  989  120  QC6- Inspect dimensions to drawing QC  Memo  0.00  Memo  0.00  DAS  27  989  95				_	Tool ID	Tool #			-			
100  *100  *100  *100  Purchasing  Memo  100  Supplier: McMaster-CarrMaterial release note is required  110  Receive & Inspect for Damage & Mat'l Certs Packaging  Memo  100  *110  *10  *100  *	Draw Nbr	Revision Nbr						,				
Purchasing  Memo  O.00  Purchasing  Neceive & Inspect for Damage & Mat'l Certs Packaging  Memo  O.00  Receive & Inspect for Damage & Mat'l Certs Packaging Packaging  Memo  O.00  Ackaging  Memo  O.00  DAS  27  DAS  28  DAS  27  DAS  27  DAS  28  DAS  DAS  DAS  DAS  DAS  DAS  DAS  DA	D3456	Rev A										
Purchasing  Memo  1.00  Purchasing  Susue P/O: 20 50 P/N: 91525A120 per Dwg D3456Possible Supplier: McMaster-CarrMaterial release note is required  110  Receive & Inspect for Damage & Mat'l Certs  0.00  *110* Packaging  Memo  Packaging  Packaging  Packaging  Packaging  OCC  Memo  0.00  DAS  27  9.89  120  Memo  0.00  Memo  0.00  Memo  0.00  Memo  0.00  DAS  27  9.89  Memo  0.00	100			0.00								
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Supplier: McMaster-CarrMaterial release note is required  110 Receive & Inspect for Damage & Mat'l Certs 0.00  *110* Packaging  Memo  0.00  Packaging  DAS  27  989  120  QC6- Inspect dimensions to drawing  QC  Memo  0.00  Memo  0.00  DAS  27  989  989  120  Memo  0.00  Memo  0.00  Memo  0.00	Purchasing			0.00					C_1_112	,,,,		-
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Packaging  Ensure Material Release Note is attached  DAS 27 989  *120  QC6- Inspect dimensions to drawing  OC  Memo  O.00  Memo  O.00  Memo								1/2/	1/01/20	g (_,	25/	
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*120* $0.00  14/1) \downarrow 2/1$	120	OC6- Inspect dimer	nsions to drawing	9.0	, 39 <sub>)</sub>							
QC $\frac{1}{1}$ $\frac{1}{1}$ $\frac{1}{1}$		Q CO Mispool dimoi		,,,				<b>S</b>	•			
I		Memo		0.00 197)	121							
	Quality Control											

DQA: _ QA Closed:			Date: _			WORK ORDER NON-	-cc	ONFO	RMANCE / U	DAIL	さいるご さいいこ Vork Order up	odate only	DART	
Work Order:				DISPOSITION		AGAINST DEPARTMENT/PROCE					, <u></u>			
Part No				Rework Scrap Use-as-is Suspected Unapproved		Machining Small Fa		Crosstube Small Fab Finishing Composite	-	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other			
Root		_	_		Desci	ription of work order update		nitial	i	tion	Sign &		001	
Cause	$\dashv$	Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector	
Design Doc/Data														
Equip/Tooling									ļ					
Handling/Pre											,			
Material			i											
Operator														
Offset/Setup	_													
Process														
Supplier														
Training														
Transport											1			
Unapproved													1	
							FAI	ULT CA	TEGORY					
Landi	ng G	iear			_	General				_	_	_	<b>-</b>	
		Bending				Bend		Folio/F	Program	L	Outside Dim	ensions	Pressure/Forced	
		Centre No	ot Concer	ntric		BOM/Route	ļ	Grain		· L	Over/Under	<del></del>	Set-up	
		Cracks				Broken/Damage/Defect		Hardwa	are	L	Part Incorre	cí _	Temperature/Cure	
		Crimp/Kir	nk/Ripple	/Wave		Burrs	L	Inspect	ion Incomplete/L	Jnqualified	Part Lost/M	issing	Weld	
		Cuffs				Contamination	L	4	tions Incomplete	<b>├</b>	Part Moved	L	Wrong Stock Pulled	
		Crushing				Countersink		Misali	gned/off center	L	Positioned V	Vrong	_	
		Heat Trea	at			Cut Too Short		Mislab	eled	Ĺ	Power Loss/	Surge	Other	
		Inspectio	n Strip in	Tube		Drawing		Misrea	d					
		Marks/Ch	natter			Drill Holes		Off-set						
		Turning S	equence			Finish		Out of	Calibration					
Wave/Twist in Tube			Fit/Function		Out of Sequence									

Work Order ID 111514 \*111514\* Page 2 January-15-14 1:17:06 PM Item ID: D3456-1 Accept \*N900040100\* Setup Start **Revision ID:** Stop Washer **Item Name:** \*40\* **Start Date:** 1/15/14 **Start Oty: 40.00 Cust Item ID:** Required Date: 1/30/14 Req'd Oty: 40.00 \*40\* **Customer:** Reference: Start Run Process Plan: Date: **Tooling:** Date: Approvals: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Set Up/ **Tool ID** Tool # Plan Accept Reject Reject Insp. Operation Work Center ID **Description** Oty Number Stamp Code Oty **Run Hours** Identify as per dwg & Stock Location: 500 0.00 130 \*130\* 0.00 Packaging Memo Packaging 140 QC21- Final Inspection - Work Order Release 0.00

0.00

Memo

1

\*140\*

Quality Control

26 9-89

MLJ 1401-21

DQA: Date:				WORK ORDER NON-CONFORMANCE / UPDATE									
QA Closed:			Date:			WORK ORDER HOR	-00		MINIARCE / OF DATE	Wo	ork Order up	date only	AEROSPACE
Work Orde	er:				ì	DISPOSITION			AGAINST	DEI	PARTMENT	PROCESS	
Part No			<del>-</del> -	Rework Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Suspected Unapproved Large Fab Composite		Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other					
Root					Desc	ription of work order update	[ i	nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved													
							FA	ULT CA	TEGORY				
Landi	_	Bending				<b>General</b> Bend		4	Program		Outside Dim	<u> </u>	Pressure/Forced
	Landing Gear  Bending  Centre Not Concentric  Cracks  Crimp/Kink/Ripple/Wave				BOM/Route Broken/Damage/Defect Burrs		Grain Hardwa	are cion Incomplete/Unqualified		Over/Under Part Incorred Part Lost/M	ci _	Set-up Temperature/Cure Weld	
		Cuffs Crushing		, wave		Contamination Countersink		Instruc	tions Incomplete/Unclear gned/off center	E	Part Moved Positioned V		Wrong Stock Pulled
		Heat Trea	n Strip in	Tube		Cut Too Short Drawing Drill Holes		Mislabo Misrea Off-set	d		Power Loss/	Surge	Other
Marks/Chatter Turning Sequence Wave/Twist in Tube					Finish Fit/Function	F	Out of Calibration Out of Sequence						

### Picklist-Print

January-15-14 1:17:05 PM

Work Order ID:

111514

Parent Item:

D3456-1

**Parent Item Name:** 

Washer

**Start Date:** 1/15/14

Required Date: 1/30/14

Page 1

**Start Qty: 40.00** 

Required Qty: 40.00

Comments:

IPP A05.10.03New issueKJ/JLM

ment Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
Purchased	No			100	Each	0.0000	1	40	-6		
				Turcii 2000.	Turen 2000.000 Seq.12	Turch 2000000 Seq 20	Turch 2000 Seq 10	Turch Louisian Soque	Turch Step Step Step Step Step Step Step Step	Turch Seq.15	Turch 100 Seq.15

/c/4/01/21 (20)

															•
DQA:			Date:			WORK ORDER NON	~	NICOI	DAANCE / HI	DATE				•	DART
QA Closed:			Date:			WORK ORDER NON	-00	NITO	RIVIAINCE / UI		∕or	k Order up	odate only		AEROSPACE
Mark Ord	a = :					DISPOSITION				AGAINST D	EP/	ARTMENT	/PROCESS		
Work Ord Part I NCR I	۰ ِ No.					Rework Scrap Use-as-is Suspected Unapproved		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite			Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root					Desc	ription of work order update	1	nitial	Act			Sign &		-	
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption	1	Date	Verificatio	n	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved															
Опарриотеа	<u>.                                    </u>		<u> </u>		<u> </u>		FA	ULT CA	TEGORY			- "	<u> </u>		
Land	ing (	Gear				General									
		Bending Centre N Cracks Crimp/Ki Cuffs Crushing Heat Tree	nk/Ripple			Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short		Grain Hardwa Inspect Instruct	ion Incomplete/Ur tions Incomplete/U gned/off center	· -		Outside Dim Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	tolerance ct issing Wrong		Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
}		Inspectio	n Strin in	Tube		Drawing		Misrea	4	_					· -

Off-set

Out of Calibration

Out of Sequence

Marks/Chatter

Turning Sequence

Wave/Twist in Tube

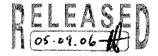
Drill Holes

Fit/Function

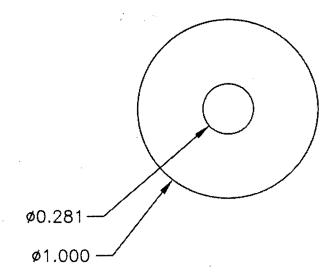
Finish



DESIG	CP	DRAWN BY	DART	AEROSPACE PORT HADLOCK, V	
CHEC	KED	APPROVED .	DRAWING NO.		REV. A
	一世	1	D3456		SHEET 1 OF 1
DATE	<del>/////////////////////////////////////</del>		TITLE		SCALE
05.0	09.01		WASHER		2:1
A		05.09.01	NEW ISSI	JE	



## SPECIFICATION CONTROL DRAWING



#### D3456-1 WASHER

- 1) MATERIAL: 316 STAINLESS STEEL, 0.050" THICK
- 2) MAY PURCHASE McMASTER-CARR P/N 91525A120
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

BILLISIY ( 14-01-16

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Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7

Tel: 613 632 9577 Fax: 613 632 1053

### **PURCHASE ORDER**

Purchase Order ID PO22652

Purchase Order Date 1/17/2014 PO Print Date 1/17/2014

Page Number 2 of 4

Order From:

MCMASTER-CARR SUPPLY CO, P.O. BOX 7690

CHICAGO, IL 60680-7690

US

VU-MCM001

Ship To: DART AEROSPACE LTD

1270 ABERDEEN

HAWKESBURY, ON K6A 1K7

**CANADA** 

Contact Name

Vendor Phone

Ship To Contact

Ship To Phone

330 995 5500

FedEx PI collect

Buyer **Customer POID**  Chantal Lavoie

Customer Tax #

Terms

10127-2607 Net 10

Currency

USD

**FOB** 

FCA - (Free Carrier)

Ship Via: Ship Acet:

95606A170

Washer

1/20/2014

200.00

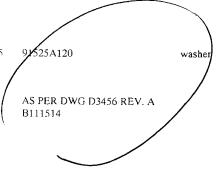
Each

1/20/2014

AS PER DWG D3631 REV. A

B111546

Yes



1/20/2014 Yes

1/20/2014

100.00 Each Line Total:

Line Total:

Line Total:

\$158.40

\$17.20

\$17.20

\$26.64

\$0.27

\$0.09

\$26.64

71500-35

4073A31 BLADES

1/20/2014

1/20/2014

Yes

3.00

Each

\$13.86

\$41.58

3 PK OF 5

Note:

Page 2 of 2

200 Aurora Industrial Pkwy Aurora OH 44202-8087 330-995-5500 cle.sales@mcmaster.com

Charges for this shipment

Merchandise Amount

Total:

\$569.86

\$569.86

Dart Aerospace Ltd 1270 Aberdeen St Hawkesbury ON K6A 1K7 Canada

Order Placed By Chantal Lavoie

01/17/2014

McMaster-Carr Number 6730369-01

ine	Description	Ordered Shipped	LNS <b>A15</b>
91525A120	120 Type 316 Stainless Steel Large-Diameter Flat Washer, 1/4" Screw Size, 1" OD, .04"06" Thick, Packs of 25	1 1 2- 702	5
1	Unit Price: \$26.64 Extended Price: \$26.64		No.
6 4073A31	1 24 TPI Replacement Blades for 4073A33, Air-Powered Mini Reciprocating Saw, Packs of 5 Your Part Number: 71500-35	3 3 1 - 106 Packs	6
	Unit Price: \$13.86 Extended Price: \$41.58	·	
<sup>7</sup> 5386A <b>7</b>	Black Adjustable Wrench, Standard, Plain Handle, 18" L, 2-1/16" Jaw Cap, Daryl Your Part Number: <b>71500-15</b>	1 1 1 - 497	7
	Unit Price: \$78.40 Extended Price: \$78.40		
5386A3	Black Adjustable Wrench, Standard, Plain Handle, 8" L, 1-1/8" Jaw Capacity, Carl Your Part Number: <b>71500-15</b>	1 1 1 1 - 497 Each	8
	Unit Price: \$16.50 Extended Price: \$16.50		·
5386A8	Black Adjustable Wrench, Standard, Plain Handle, 4" L, 1/2" Jaw Capacity, Carl Your Part Number: <b>71500-15</b>	3 - 3 1 - 497 Each - 3	9
	Unit Price: \$13.58 Extended Price: \$40.74		
) 5386A8	Extended Price: \$16.50  Black Adjustable Wrench, Standard, Plain Handle, 4" L, 1/2" Jaw Capacity, Carl Your Part Number: <b>71500-15</b> Unit Price: \$13.58	- 1 - 47/	